

Date: Monday, 2/11/2008 11:36:53 AM
 User: Eric Charbonneau

Q Metro

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BK117 SKIDTUBE ASSEMBLY
Job Number : 32910	
Estimate Number : 12898	
P.O. Number :	Part Number : D117762041
This Issue : 2/11/2008 S.O. No. :	Drawing Number : D3582 REV <i>UR 1A</i>
Prsht Rev. : NC	Project Number : LG0005
First Issue : 6/14/2007 Type : LANDING GEAR	Drawing Revision : <i>UR 1A</i> 01.02.10
Previous Run :	Material :
Written By :	Due Date : 6/22/2007 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 07.06.11 New Issue EC	

USED FOR
 D117-762-041
 B33139

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

2.0	D2962150P	3.540 Outer Tube, Extrud
-----	-----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2962-150 Extrusion *B28672*

DP 08.02.01

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

DP 08.02.01

4.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: BENDING MACHINE

Bend tube as per program *D3582* on CNC Bender and Dwg D3582. Use 5/16" locator pin on buggy "A".

DP 08.02.01

Date: Monday, 2/11/2008 11:36:54 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 32910

Part Number: D117762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Cut Fwd end of the tube using DT8185
- 2-Cut Aft end at VC using DT8185
- 3-Deburr ends
- 4-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***
- 5-Locate DT & Drill Ground wire hole on top of Tube.
- 6-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.
- 7-Drill pilot holes for wearplates using DT
- 8-Open wearplate holes and ground wire holes to Ø19/64" (0.297") as per Dwg D3582.
- 9-Open Aft Cap holes using .209" drill.
- 10-Deburr holes.

DP 08.02.04

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cap

Batch: B14101

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Weld fwd cap D2964 per dwg D3582 and QSI 004
A/R AL ROD Batch: M104305/M102421/M104221

BE 08.02.04

- 2-Grind flush

Date: Monday, 2/11/2008 11:36:54 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 32910

Part Number: D117762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

8.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

AA 08.02.05

9.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

AA 08.02.05

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

DP 08.02.05

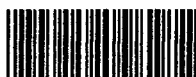
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
------	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PH 08.02.05

12.0	D35841	WEB
------	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
WEB BATCH : B32911

DP 08.02.05

13.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
------	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1
1-Open X-Bolt holes to .750"(4Places) as per Dwg D3582, section B-B

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: M103561/M104732 ~~M104732~~
Exp Date: 7-10-1/8-1-1

5-Weld x-bolt spacers as per Dwg D3582.

A/R AL ROD Batch: M104305 *BE* 08.02.03
M106330

6-Grind welds flush

DP 08.02.03

Date: Monday, 2/11/2008 11:36:54 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 32910

Part Number: D117762041

Job Number:



Seq. #: Machine Or Operation: Description :

Tools: E

14.0

D2971

Cross Bolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cross Bolt Spacer

batch: B33221

15.0

D36621

SPACER



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

SPACER

batch: B37189

16.0

D36623

SPACER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

SPACER

batch: B37190

17.0

D2973

Cross Bolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cross Bolt Spacer

Batch: B14636

18.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.02.07

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.02.12 08.02.08

20.0

POWDER COATING

POWDER COATING



M106379



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l 08/02/12

Date: Monday, 2/11/2008 11:36:54 AM

User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 32910

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RH 01.12.12

22.0

ALS71032130

Insert

NOT REQ'D
DUPLICATE OF STEP 24

Comment: Qty.: 38.0000 Each(s)/Unit Total : 76.0000 Each(s)

Insert

Batch: M6989

23.0

ALS4428165

Inserts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inserts (or ALS7-428-165)

batch: M6989

24.0

ALS41032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 76.0000 Each(s)

Insert BATCH: M103495

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3582.

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Inserts

RH 03.12.12 03.12.03

27.0

D2965

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cap

Batch: B36033

Date: Monday, 2/11/2008 11:36:54 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 32910

Part Number: D117762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

28.0	D35083	WEARPLATE
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
WEARPLATE
Batch: B33020

29.0	D35089	WEARPLATE
------	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
WEARPLATE
Batch: B33013

30.0	D350811	WEARPLATE
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
WEARPLATE
Batch: B33011

31.0	D350813	WEARPLATE
------	---------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
WEARPLATE
Batch: ~~B33012~~ B36416

32.0	D35583	GASKET
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
GASKET
Batch: B B33021

33.0	D35589	GASKET
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
GASKET
Batch: B33016

34.0	D355811	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
GASKET
Batch: B33014

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 32910

Part Number: D117762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

35.0	D355813	GASKET
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
GASKET
Batch: B33015

36.0	D3492049	PLUG ASSEMBLY
------	----------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
PLUG ASSEMBLY
batch: B37288

37.0	D3492051	PLUG ASSEMBLY
------	----------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
PLUG ASSEMBLY
batch: B37289

38.0	D3492053	PLUG ASSEMBLY
------	----------	---------------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 12.0000 Each(s)
PLUG ASSEMBLY
batch: B37290 B37474

39.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: ~~200~~ 60.0000 Each(s)/Unit Total : 60.0000 Each(s)
BOLT
Batch: M103641

40.0	AN3C5A AN3-5A	Bolt
------	---------------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
Batch: M104118 M100138

41.0	AN960C10L AN960C10L	washer
------	---------------------	--------



Comment: Qty.: ~~20~~ 64.0000 Each(s)/Unit Total : 64.0000 Each(s)
washer
Batch: M102473

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 32910

Part Number: D117762041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

42.0	AN44A	Bolt
------	-------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt
batch: M106918

43.0	AN960JD416L	Washer
------	-------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
batch: M106785

44.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: M105585
Exp Date: 07-08

3-Install Wearplates as per Dwg D3582 ,

Note: Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex Batch: M105585
Exp Date: 07-08

4- Wing Walk as per Dwg D3043 and QSI 005 4.4

45.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

08-02-09

46.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D117-762-041

Location: _____

PPP Rev: _____

Date: Monday, 2/11/2008 11:36:54 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BK117 SKIDTUBE ASSEMBLY

Job Number: 32910

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

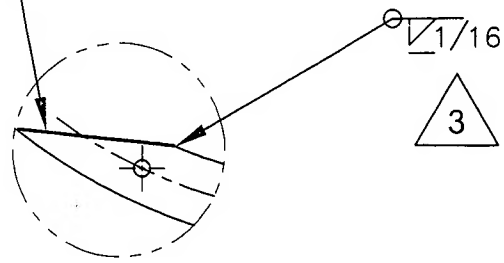
208/04/07

Job Completion

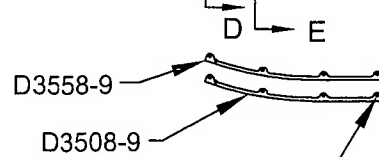
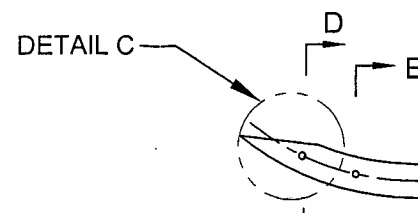


N/A FOR
CONFORMITY
PA
08-02-12

D2964 CAP
(GRIND FLUSH)



DETAIL C
SCALE 1:10



NO BOLTS AT
THESE LOCATIONS



D3558-3

D3558-11

D3508-3

D3508-11

D3558-13

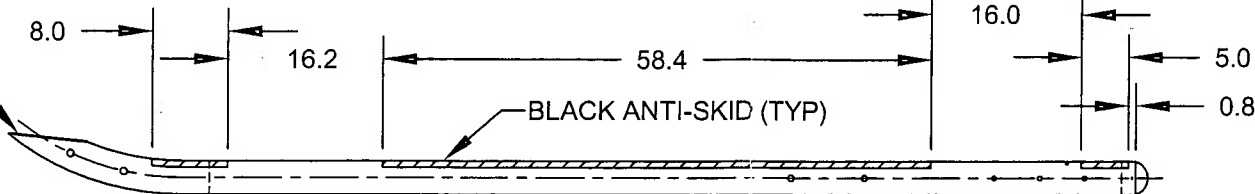
D3508-13

NO BOLTS AT
THESE LOCATIONS



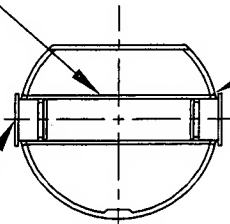
D3582-041 ASSEMBLY DETAIL

BLACK ANTI-SKID



D3582-041 BLACK ANTI-SKID DETAIL

D2971 SPACER



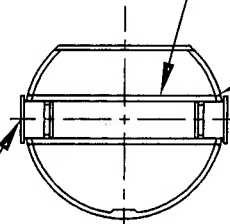
SECTION D-D
SCALE 3:10

AFTER FINISH
INSTALL,
D3492-049
PLUG ASSEMBLY
(2 PLACES)

AFTER FINISH
INSTALL,
D3492-051
PLUG ASSEMBLY
(2 PLACES)

SECTION E-E
SCALE 3:10

D3662-3 SPACER



SECTION D-D NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

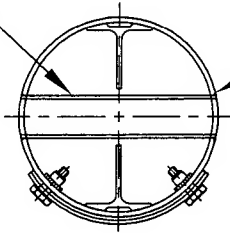
1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2971 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-049 PLUG ASSEMBLY (2 PLACES)

SECTION E-E NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-3 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.672 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-051 PLUG ASSEMBLY (2 PLACES)

D2973 SPACER
(2 PLACES)



SECTION F-F
SCALE 3:10

SECTION F-F NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D2973 SPACER (2 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.625 DRILL TO REMOVE SPILL OVER

D3584-1 WEB (REF)

D3662-1 SPACER
(3 PLACES)

AFTER FINISH, INSTALL
AELS-1032-130
INSERT (36 PLACES)

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(28 PLACES)

SECTION G-G
SCALE 3:10

SECTION G-G NOTES

AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:

1. CHAMFER HOLE 0.030 x 45°
2. INSERT D3662-1 SPACER (3 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER
5. AFTER FINISH, INSTALL D3492-053 PLUG ASSEMBLY (6 PLACES)

AFTER FINISH, INSTALL
ALS7-428-165 INSERT (1)
AN4-4A BOLT (1)
AN960JD416L WASHER (1)
(2 PLACES)

AFTER FINISH
INSTALL,
D3492-053
PLUG ASSEMBLY
(6 PLACES)

D3584-1 WEB
(REF)



SEAL WITH
SIKAFLEX -241/-291

D2965 CAP

AN3-5A BOLT (1)
AN960JD10L WASHER (1)
(2 PLACES)

DETAIL H
SCALE 1:5

RELEASED

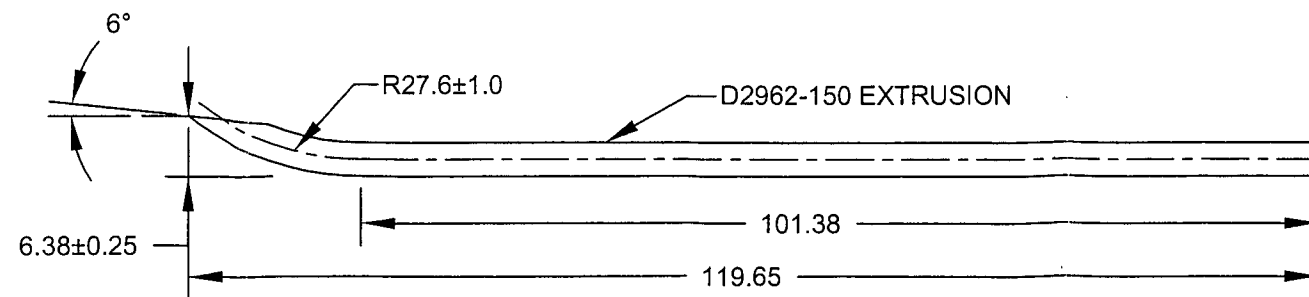
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	h	DRAWING NO.	REV. A
MFG. APPR.	h	D3582	SHEET 2 OF 2
APPROVED	h	TITLE	SCALE
DE APPR.	h	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

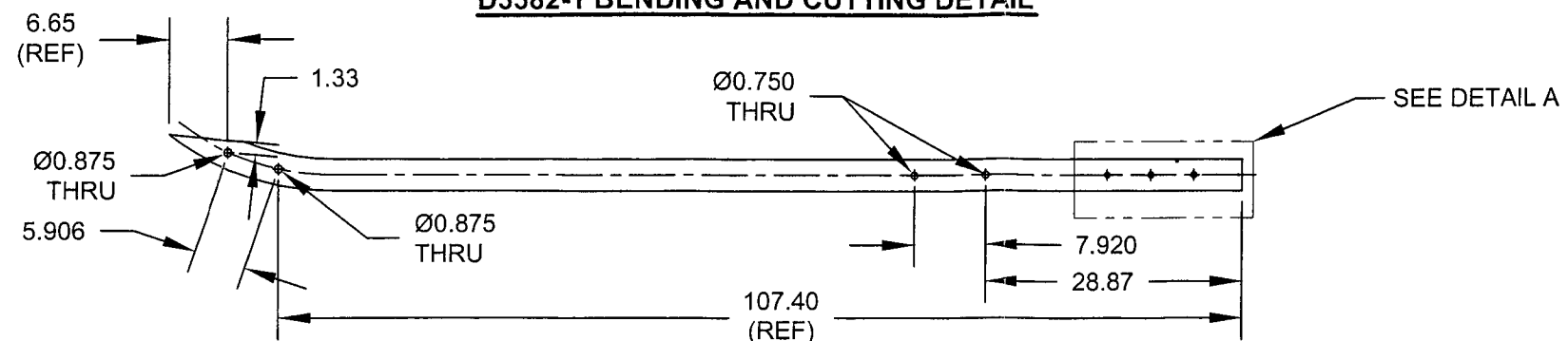
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

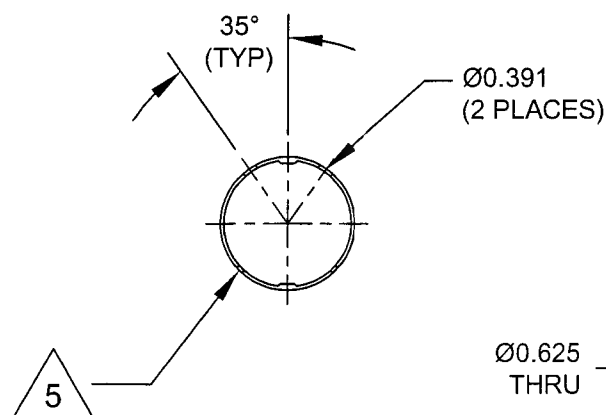
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



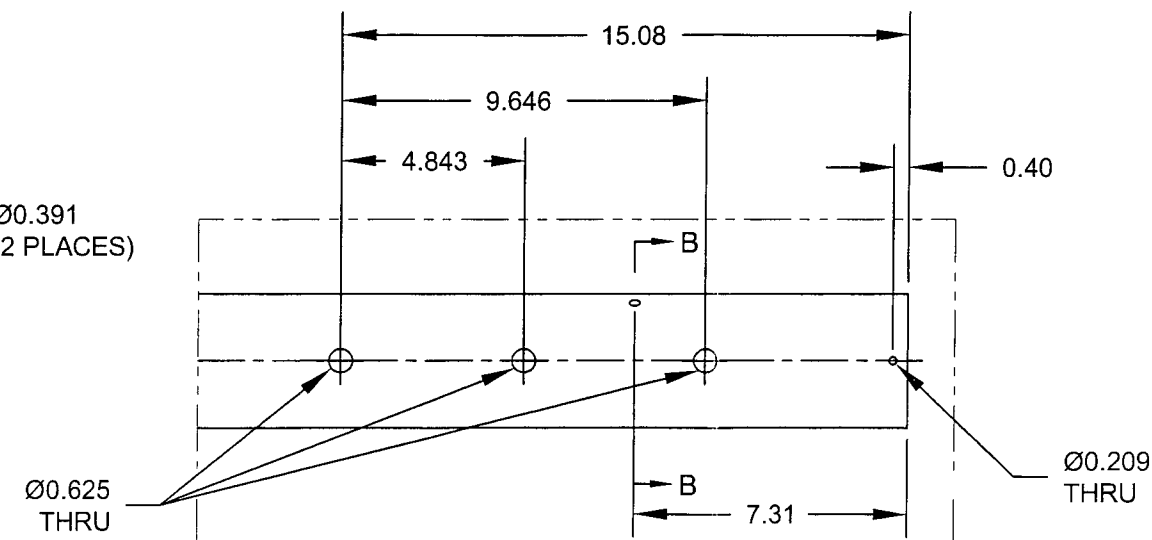
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5



DETAIL A
SCALE 1:5

RELEASED
07.11.22

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3582	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Date:
User:

Process Sheet

Customer
Job Number
Estimate Number
P.O. Number
This Issue
Prsht Rev.
First Issue
Previous Run
Written By
Checked & Ap
Comment

Date,

Please file this in
the D117-762-011 file

Thanks, Peter

エアロファシリティ株式会社

Tel 03-5574-7655

Drawing Name : BK 117 SKIDTUBE

Part Number : ENGINEERING

Drawing Number : BK 117 SKIDTUBE

Project Number : LG0005

Drawing Revision : N/A

Material :

Due Date : 10/4/2006

Qty: 1 Um: Each

IR

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

ENGINEERING 1

ENGINEERING RESOURCE #1



Comment: ENGINEERING RESOURCE #1

Project Evaluation:

Involved: Marketing, Sales, Eng & Manegment

70117762041 B32910 and D117-762-011

B33139

080118

Comments:

RE-WORK

D2971 B33221 2Pc

D3662-3 B37190 2Pc

D3662-1 B37189 6Pc

BE 08/02/06

ALuminum ROD m106330

- Inspect QC #9 PD 08-02-06
welding

- Inspect QC #5
work to current step 08/02/06

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: BK 117 SKIDTUBE

Job Number: 00083

Part Number: ENGINEERING

Job Number:



Seq. #:

Machine Or Operation:

Description :

RE-FINISH

QC3 PAINT
INSTALL AELS-1032-130 INSERT (36) B QTY(2)
ALS2-423-165 INSERT (2) B M679 6989 (4)

INSTALL WEARPLATES AND GASKETS

D3507-3

D3558-3

CAP

D3965 B36033

D3507-13 B36416

USING AN324A BOLTS
AN960C10L WASHER

SEE
ATTACHED

INSTALL AN4-4A M106918 (SECTION G-G) 12 PLACES)
AN9605D416L M106785

INSTALL D3492-049 PLUGS (2) B37288
D3492-051 " (2) B37289
D3492-053 " (6) B37290

TURN OVER

2.0

ENGINEERING 1

ENGINEERING RESOURCE #1



Comment: ENGINEERING RESOURCE #1

Input Review:

Involved: Sales, Eng & Manufacturing Eng

Comments:

- QC # 5 inspect Final work
- QC # 6 inspect work

08.02.12

D3512-1 B 36180 QTY (2)

3.0

MFG ENGINEERING

MFG ENGINEERING



Comment: MFG ENGINEERING

Create Initial Estimate :

Involved: Management & Mfg Engineering

N/A 08.02.14

• INSTALL 02965 CAP B30033

AM3-SA BOLT
~~AN96050101~~ WASHER (2)
AN3-SA BOLT M10017
AN96050101 WASHER M104735

• WING WALK PER D3582

• 10/10/10

• 10/10/10

• 10/10/10

• 10/10/10

• 10/10/10

Process Sheet

Drawing Name: BK 117 SKIDTUBE

Part Number: ENGINEERING

[illegible]

Comments:

...the ... of ...

[illegible]

Comments:

V/12 ~~24~~
03.02.14

[illegible]

1000

[illegible]

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and resources. This may involve researching existing solutions, consulting with experts, or collecting data.

3. The third step is to develop a plan or strategy. This involves breaking down the problem into smaller, manageable tasks and determining the sequence of steps to be taken.

4. The fourth step is to implement the plan. This involves carrying out the tasks and making adjustments as needed based on feedback and progress.

5. The fifth step is to evaluate the results. This involves comparing the outcomes against the original goals and objectives to determine the effectiveness of the solution.

6. The sixth step is to document the process and findings. This involves creating a record of the steps taken, the resources used, and the results achieved, which can be useful for future reference.

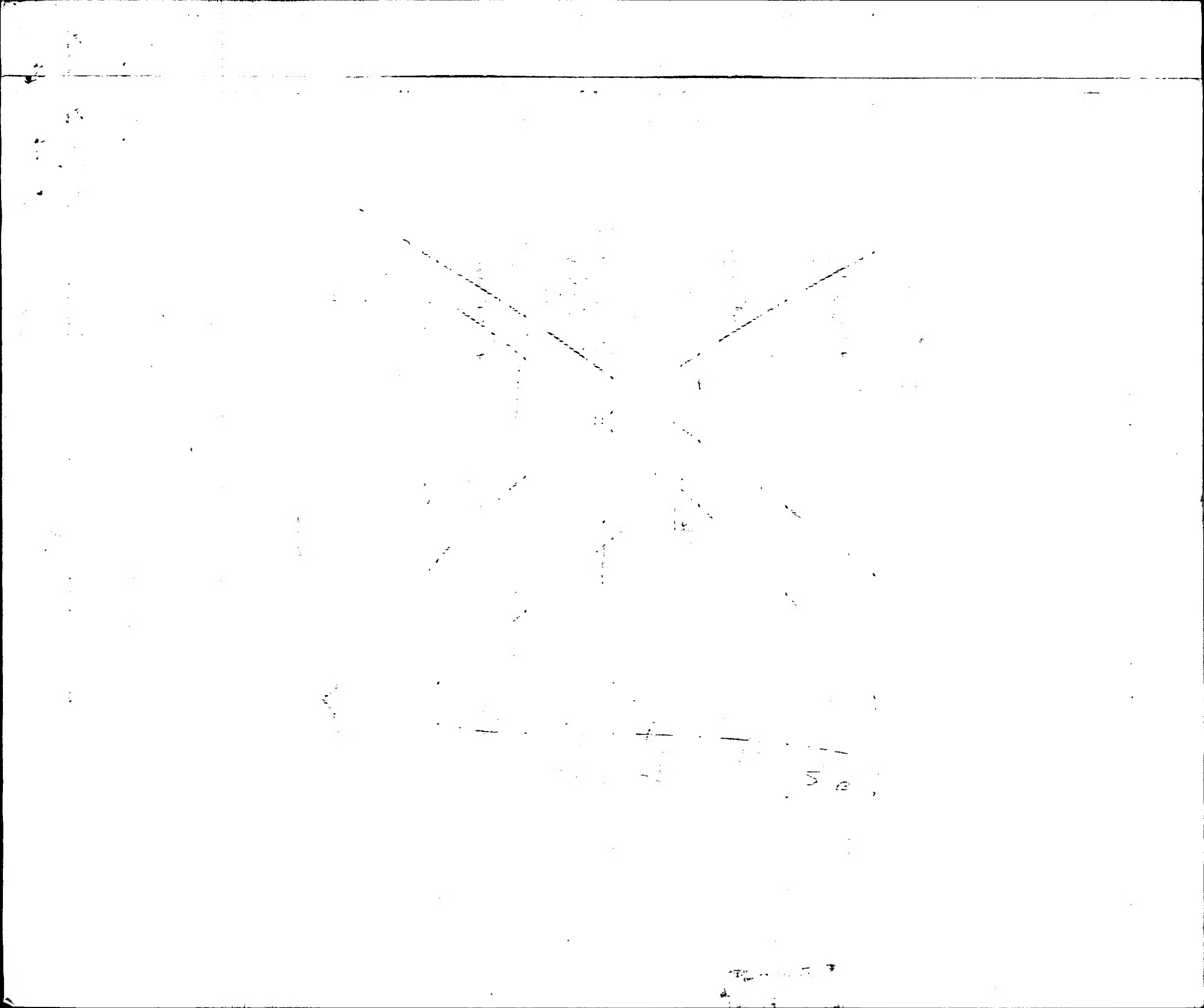
7. The seventh step is to communicate the results. This involves sharing the findings with the relevant stakeholders and providing a clear summary of the outcomes.

8. The eighth step is to reflect on the process. This involves considering what worked well, what challenges were encountered, and how the process could be improved for future tasks.














9. The ninth step is to conclude the project. This involves finalizing all tasks and ensuring that all objectives have been met.

10. The tenth step is to celebrate the success. This involves acknowledging the efforts of the team and the successful completion of the project.

Comment: ENGINEERING RESOURCE #1
Final Design Review:
Involved: Marketing/Sales, Mfg Engineering & Management
Comments:



Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.		Drawing Name: BK 117 SKIDTUBE	
Job Number: 00083		Part Number: ENGINEERING	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
10.0	MFG ENGINEERING	MFG ENGINEERING	
			
Comment: MFG ENGINEERING 1-Create NC programs if Applicable 2-Create Tooling if Applicable 3-Link 1st W/O (s) to Project W/O FOR 1ST Production Unit			
11.0	OUTSIDE SERVICE	OUTSIDE SERVICES	
			
Comment: Sub-Contracting OUTSIDE SERVICES(Acuren Group p/o 2524 testing & analysis			
12.0	OUTSIDE SERVICE	OUTSIDE SERVICES	
			
Comment: Sub-Contracting TRADEWIND P/O 2232 PART # 1121-51002 SKID SHOE			
13.0	OUTSIDE SERVICE	OUTSIDE SERVICES	
			
Comment: Sub-Contracting TRADEWIND P/O 2232 PART # 1121-51102 clamping ring			
14.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1			
15.0	QC21	FINAL INSPECTION/W/O RELEASE	
			
Comment: FINAL INSPECTION/W/O RELEASE			

Job Completion



Parts used on 00083 ~~PH~~ 08.02.12

Part Number	Batch	QTY
D2965	B36033	2 1
D3508-13	B36416	2 1
D3512-1	B36180	4 2
D3492-049	B37288	2
D3492-051	B37289	2 4
D3492-053	B37290	2 7
ALS4-428-165	B6989	2
AN3-5A	M100188	2
AN4-4A	M106918	2
AN960JD416L	M106785	2
AN960JD10L	M104885	2

~~D3508-13~~

D3508-13
D3556-13

D3492-053 were changed to D3492-053 B37474

SKIDTUBE WILL BE LABELED D117-762-011 B33139 ~~PH~~
08.02.12